

Work Order ID 71669

Thursday, July 07, 2011 12:09:52 PM



Page 1

Item ID:	D4000-045	Accept		Setup	Start	
Revision ID:						
Item Name:	Fuel Pickup Fitting Assembly				Stop	
Start Date:	7/7/2011	Start Qty:	1.00	Cust Item ID:		
Required Date:	7/21/2011	Req'd Qty:	1.00	Customer:		
Reference:						

Approvals:	Process Plan:	<u>CL</u>	Date:	<u>7/10/07</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4000	A								

100 Weld per dwg A/R Aluminum rod Batch: 114703 0.00



Large Fab

Memo

0.00

Large Fab

11.07.18 4 0

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

4 0 8/1/07/18

120 QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

Quality Control

8/1/07/18

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71669

Thursday, July 07, 2011 12:09:52 PM



Page 2

Item ID:	D4000-045	Accept		Setup	Start	
Revision ID:						
Item Name:	Fuel Pickup Fitting Assembly			Stop		
Start Date:	7/7/2011	Start Qty:	1.00			
Required Date:	7/21/2011	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
124 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4	0		
126 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				H	BL 11-7-18,		
130 Packaging Packaging	Identify as per dwg & Stock Location: <u>W08</u> Memo	0.00 0.00				4	0		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71669

Page 3

Thursday, July 07, 2011 12:09:52 PM

Item ID: D4000-045

Accept



Setup Start



Revision ID:

Stop



Item Name: Fuel Pickup Fitting Assembly

Start Date: 7/7/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/18

11-07-18
4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, July 07, 2011 12:09:50 PM

Page 1

Work Order ID: 71669

Parent Item: D4000-045

Parent Item Name: Fuel Pickup Fitting Assembly

Start Date: 7/7/2011


Required Date: 7/21/2011

Start Qty: 1.00

Required Qty: 1.00


Comments: IPP rev A 10.01.20 new issue Prelim EC verified by:DD IPP rev B
10.05.13 ecn10-562 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4000-11  Cap		Manufactured	No			100	Each	12.0000	1	1		<i>11-07-18</i>	
--	--	--------------	----	--	--	-----	------	---------	---	---	--	-----------------	--


Location	Loc Qty	Loc Code
----------	---------	----------

ENG	4	
55892	4	
WA	8	
69201	8	

D4000-7  Fuel Pickup Fitting		Manufactured	No			100	Each	4.0000	1	1		<i>11-07-18</i>	
---	--	--------------	----	--	--	-----	------	--------	---	---	--	-----------------	--

Location	Loc Qty	Loc Code
----------	---------	----------

WA	4	
67677	4	

D4003-5  Fuel Pick Up Line		Manufactured	No			100	Each	6.0000	1	1		<i>11-07-18</i>	
---	--	--------------	----	--	--	-----	------	--------	---	---	--	-----------------	--

Location	Loc Qty	Loc Code
----------	---------	----------

WA	6	
67638	6	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

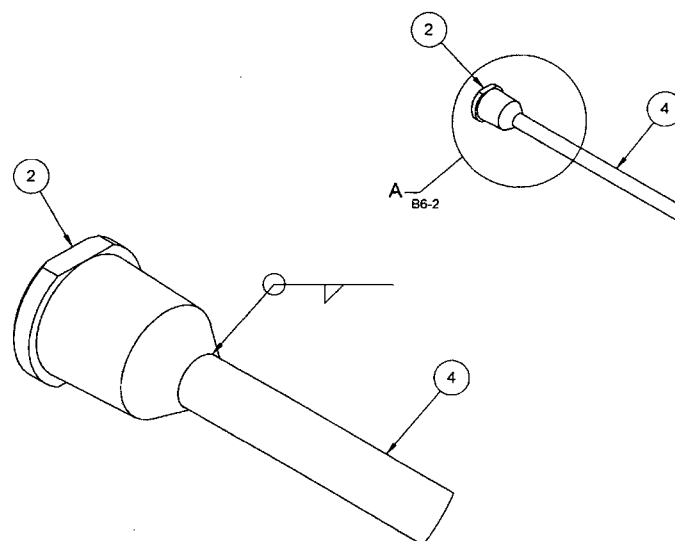
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

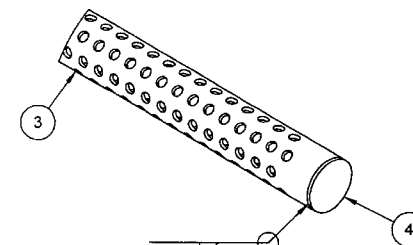
NOTE: Date & initial all entries

ITEM NO.	QTY. -047	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4000-045	FUEL PICK UP FITTING ASSEMBLY	JCA-M47-1-10
2	1	D4000-7	FUEL PICK UP FITTING	
3	1	D4000-11	CAP	
4	1	D4003-5	FUEL PICK UP LINE	



DETAIL A
SCALE 4X C6-2

D4000-045 FUEL PICKUP FITTING ASSEMBLY



DETAIL B
SCALE 4X B2-2

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71669

CZ11107/07

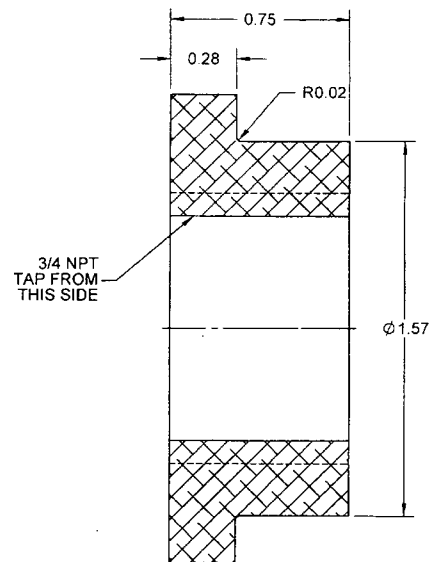
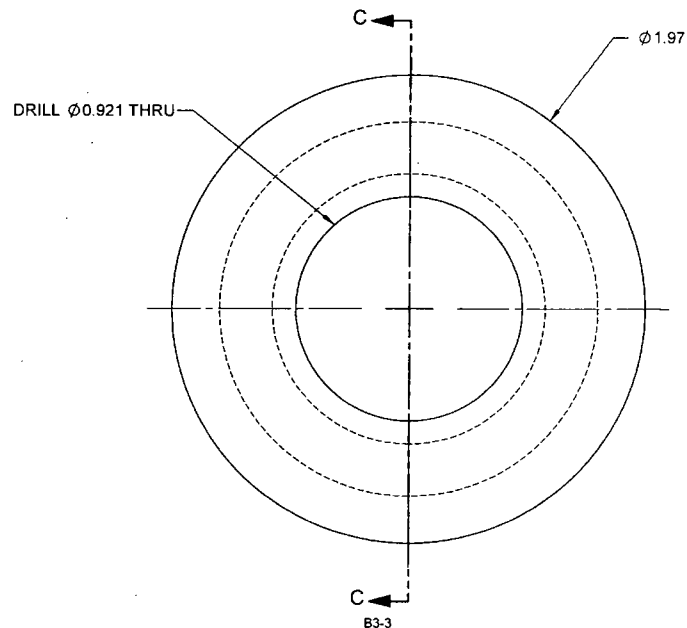
RELEASED
2010-05-05
MT

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4000-045" AND B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.27 lbs

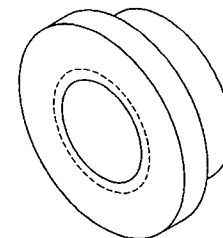
DESIGN	<i>JE</i>	DART AEROSPACE LTD	
DRAWN	<i>JE</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JE</i>	DRAWING NO. D4000	REV. A
MFG. APPR.	<i>JE</i>		SHEET 2 OF 8
APPROVED	<i>JE</i>	TITLE FITTING	SCALE NTS
DE APPR.	<i>JE</i>		
DATE	10.02.10		

COPYRIGHT © 2010 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4000-1	JCA-M47-1-04



SECTION C-C
B6-3



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71669

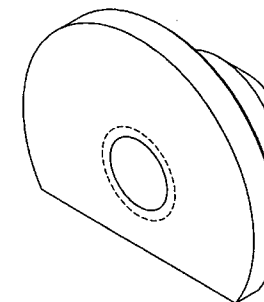
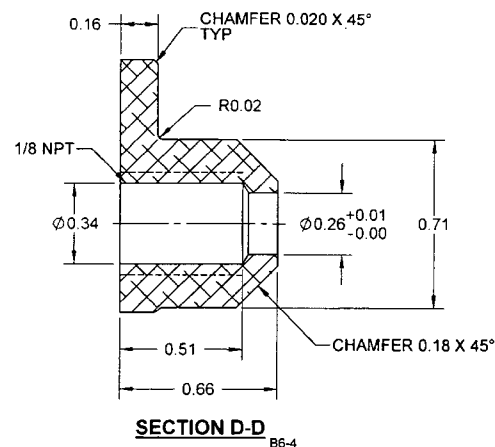
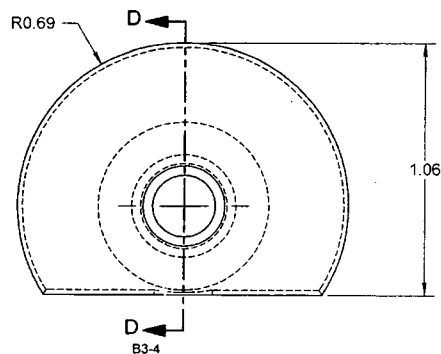
D4000-1 FUEL SUPPLY FITTING

RELEASED
2010-05-05
IMP

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6R
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.12 lbs

DESIGN	<i>JS</i>	DART AEROSPACE LTD	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JS</i>	D4000	SHEET 3 OF 8
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	FITTING	NTS
DATE	10.02.10	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4000-3	JCA-M47-1-05



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71669

D4000-3 FUEL SUMP DRAIN FITTING

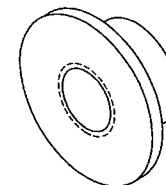
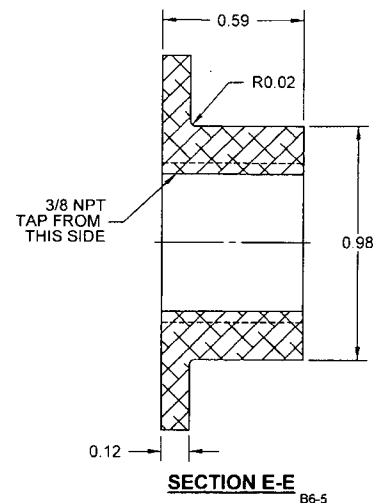
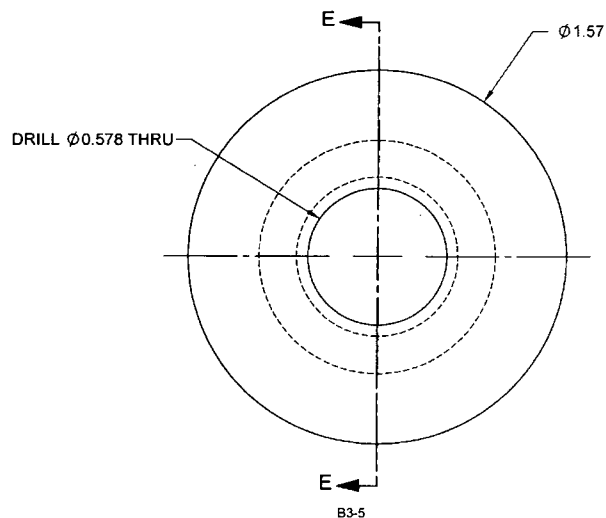
RELEASED
2010-05-05
IMP

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T6510/T6511/T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS4160)
REF DART SPEC M6061T6R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D4000	REV. A
MFG. APPR.	<i>[Signature]</i>		SHEET 4 OF 8
APPROVED	<i>[Signature]</i>	TITLE FITTING	SCALE
DE APPR.	<i>[Signature]</i>		NTS
DATE	10.02.10	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4000-5	JCA-M47-1-09



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71669

D4000-5 FUEL TANK VENT FITTING

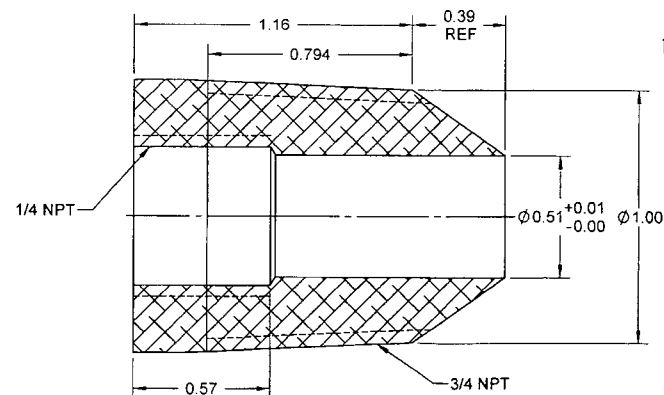
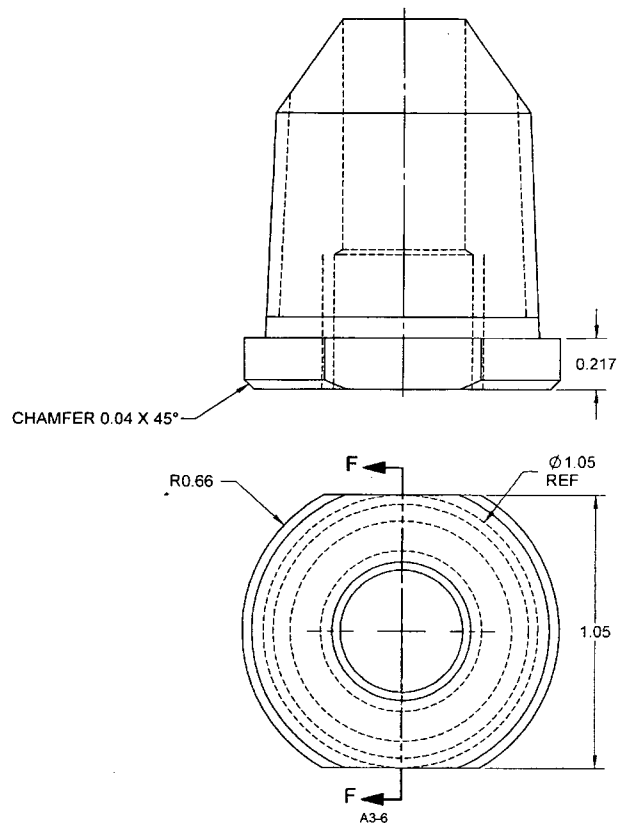
RELEASED
2010-05-05
[Signature]

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4000	SHEET 5 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FITTING	NTS
DATE	10.02.10	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4000-7	REF JCA-M47-1-10

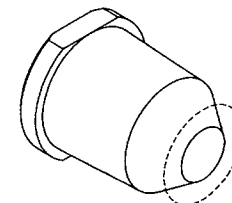


SECTION F-F
A6-6

D4000-7 FUEL PICK UP FITTING

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71669

RELEASED
2010-05-05
JMD

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4000	REV. A
MFG. APPR.			SHEET 6 OF 8
APPROVED		TITLE	SCALE
DE APPR.		FITTING	NTS
DATE	10.02.10	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4000-9	JCA-M47-1-11

DRILL $\phi 0.60$ THRU

$\phi 1.02$

G

G
B3-7

0.13 x 45° CHAMFER

0.39

$\phi 0.709$ $\phi 0.748$

0.051

0.20 0.073

SECTION G-G

B6-7







SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71669

RELEASED
2010-05-05
MD

D4000-9 GROMMET

NOTES:

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL, $\phi 1.000$ ROUND BAR
REF DART SPEC M-DELRIN-R1.000
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4000	SHEET 7 OF 8
APPROVED		TITLE	SCALE
DE APPR.		FITTING	NTS
DATE	10.02.10	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			